

# Work Order ID 74140

Monday, September 26, 2011 8:57:28 AM



Page 1

Item ID: D4016-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Half, Base

Start Date: 9/27/2011 Start Qty: 18.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 18.00



Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-09-26* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4016

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.00" LONG

*MF*  
*F.K. 11/09/30*

*18* *✓*

110

0:00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: *AA*

DWG REV: *A*

DEBURR

*MF*  
*F.K. 11/10/06*

*18* *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**Work Order ID 74140**

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Page 3

Item ID: D4016-1

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Start Date: 9/27/2011 Start Qty: 18.00

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Required Date: 9/30/2011 Req'd Qty: 18.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11  
18

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 26, 2011 8:57:26 AM

Page 1

Work Order ID: 74140



Parent Item: D4016-1



Parent Item Name: Hinge Half, Base

Start Date: 9/27/2011

Required Date: 9/30/2011

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B  
as per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B1.000X1.000

Purchased

No

100

f

24.2586

0.08

1.44



304 bar 1.00 x 1.00

F.K. 11/09/30

Location

Loc Qty

Loc Code

MAT050

24.2586

113290

1.047

117130

0.7316

✓ 118844

22.48

1.444

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74140
<b>Description:</b> Hinge Half, Base		<b>Part Number:</b> D4016-1
<b>Inspection Dwg:</b> D4016	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	.872			11-06	
0.25	+/-0.030	.238				
0.38	+0.030/-0.000	.39				
R0.03	+/-0.030	.03				
0.13	+/-0.030	.122				
0.88	+/-0.030	.876				
Ø0.257	+0.006/-0.001	.257				
R0.38	+/-0.030	.38				
0.500	+/-0.030	.500				
0.75	+/-0.030	.75				

<b>Measured by:</b> FK. Long	<b>Audited by:</b> B.A	<b>Preliminary Approval:</b>
<b>Date:</b> 11/10/06	<b>Date:</b> 11/10/11	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	MA

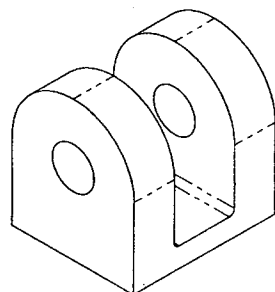
W/O:		WORK ORDER CHANGES					
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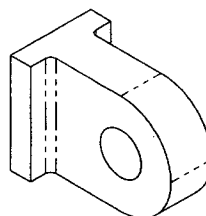
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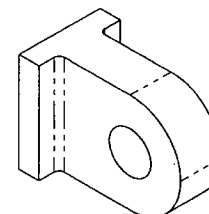
**NOTE:** Date & initial all entries



**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**



**D4016-5 HINGE HALF, LIGHT LID**

#74140

**RELEASED**  
2010-02-16  
MP

A		NEW ISSUE		JPH		10.01.29	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 2	
DRAWN	AJS						
CHECKED	RS	DRAWING NO.		REV. A		SHEET 1 OF 2	
MFG. APPR.	RS	D4016		SCALE		NTS	
APPROVED	MP	TITLE		SCALE		NTS	
DE APPR.	MP	BASKET HINGE		SCALE		NTS	
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

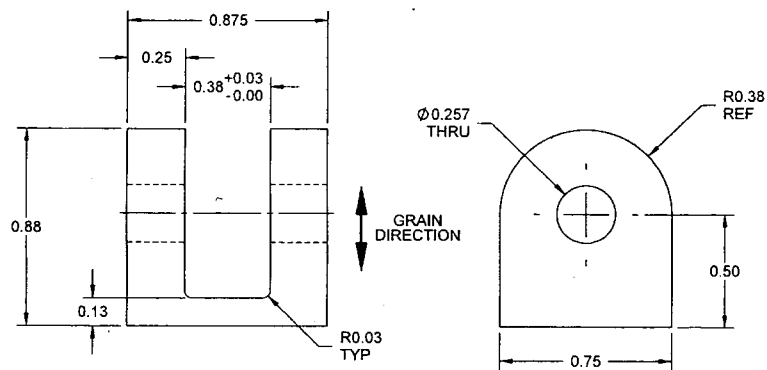
W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



**D4016-1 HINGE HALF, BASE**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6051-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

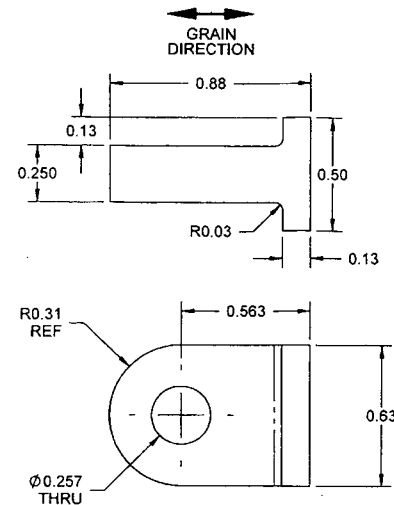
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

#74140  
**RELEASED**  
2010-02-16  
MD

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JS	<b>D4016</b>	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	<b>BASKET HINGE</b>	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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